Work Order ID 91970 *91970*

October-19-12 3:04:31 PM

Item ID: D3883-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Saddle, Outboard RH **Stop** *NS2*

Start Date: 10/30/12 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 11/05/12 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 12-10-22 **Tooling:** ____ **Date:** ____

Stop *NR2*

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3883	C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Stamp / Date	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 **Memo** Program Batch No 91970 DAS Double check by: DAS 14 9-89 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets	0.00 0.00	DAS 25 9-89 12-10-24	4			
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	DAS 25 9-89 12-10-24	4	0		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 91970 *91970*

October-19-12 3:04:31 PM

Item ID: D3883-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Saddle, Outboard RH **Stop** *NS2*

Start Date: 10/30/12 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 11/05/12 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	DAS 14 9-89 12/10/24			4	0		
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	RG 12-10-24		
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:40 OVEN TEMPERATURE: ~~320~~ 320°F FINISH TIME: 4:10	0.00 0.00				4	0		MJ 12/10/24

M122878

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	____________	

Work Order ID 91970 *91970*

October-19-12 3:04:31 PM

Item ID:	D3883-2		**Accept**	*N900040100*	**Setup** **Start** *NS1*
Revision ID:					**Stop** *NS2*
Item Name:	Saddle, Outboard RH				
Start Date:	10/30/12	**Start Qty:** 4.00	*4*	**Cust Item ID:**	
Required Date:	11/05/12	**Req'd Qty:** 4.00	*4*	**Customer:**	
Reference:					

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________ **Run** **Start** *NR1*

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	∅	12-10-25	[stamp]
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: ST437 Memo	0.00 0.00				4X			SD 12-10-25
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/10/25	[signature]

R 12-10-26

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-19-12 3:04:31 PM

Work Order ID: 91970

Parent Item: D3883-2

Parent Item Name: Saddle, Outboard RH

Start Date: 10/30/12 **Required Date:** 11/05/12

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015 Saddle Billet		Manufactured	No				Each	31.0000	SL 12-10-23	4			

Location		Loc Qty	Loc Code	
MAT041		30		
	88390	20		4
	89823	10		
MAT047		1		
	85568	1		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
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☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	____________	

DART AEROSPACE LTD	Work Order:	91970
Description: Saddle, Outboard, RH	Part Number:	D3883-2
Inspection Dwg: D3883 Rev. C		Page 1 of 1

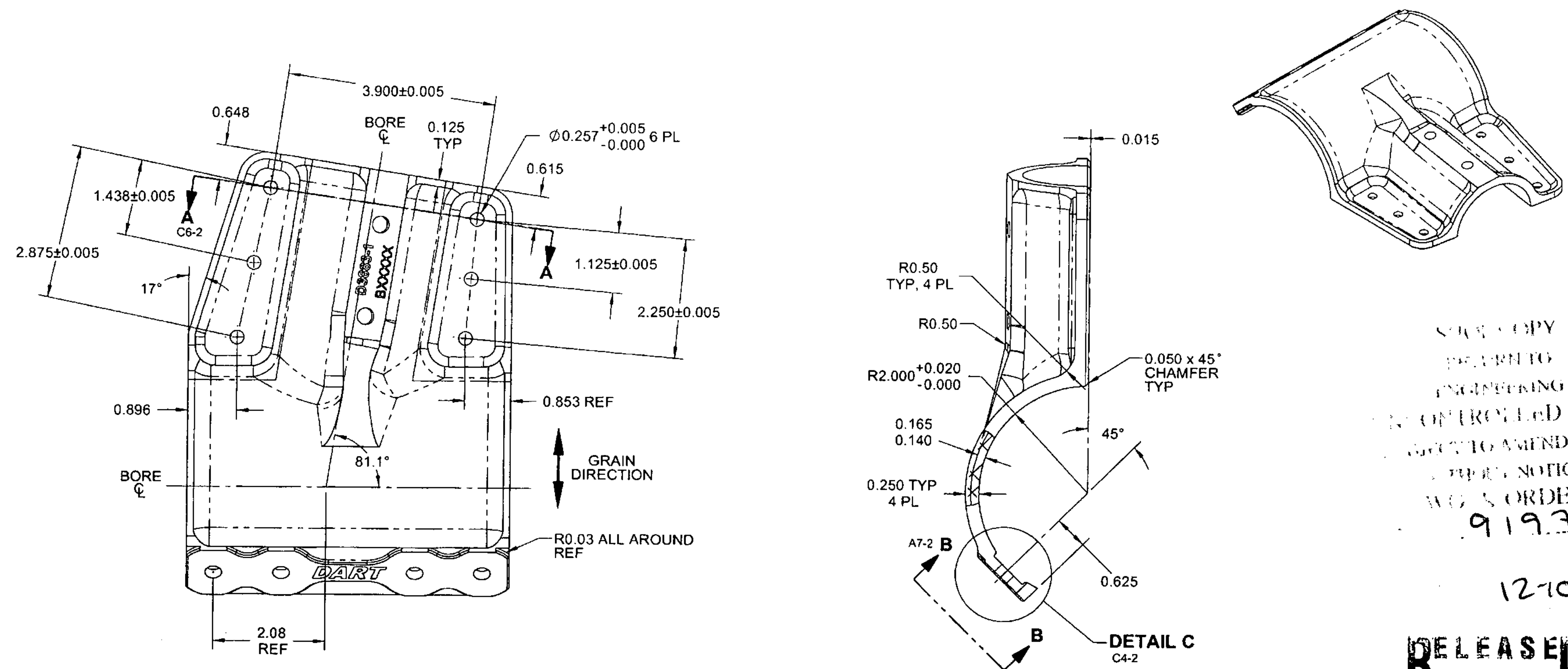
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions 1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.649	.648	.648	.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.616	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.002	2.002	2.002	2.002		
J	0.140	0.165		.150	.149	.150	.150		
K	0.240	0.260		.249	.248	.249	.249		
L	0.115	0.135		.125	.125	.125	.125		
M	0.140	0.165		.150	.150	.150	.150		
N	0.720	0.780		.770	.770	.770	.770		
O	0.240	0.260		.248	.250	.251	.251		
P	0.110	0.140		.135	.135	.135	.135		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.870	2.870	2.870	2.870		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.000	1.000	1.000	1.001		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.001	6.001	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.500	.498	.497	.499		
Y	1.220	1.280		1.25	1.25	1.25	1.25		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.316	.316	.316	.316		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.217	.217	.217	.217		
AE	1.265	1.285		1.268	1.267	1.267	1.267		
AF									
Accept/Reject									

Measured by:	JL
Date:	12-10-23

Audited by	DAS 14
Date:	9-89 12/10/24

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	



UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
W.O. ORDER 91970
MLJ 12-10-22

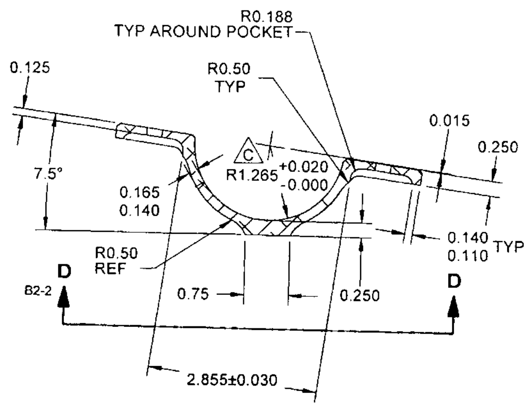
RELEASED 2009-11-19

D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

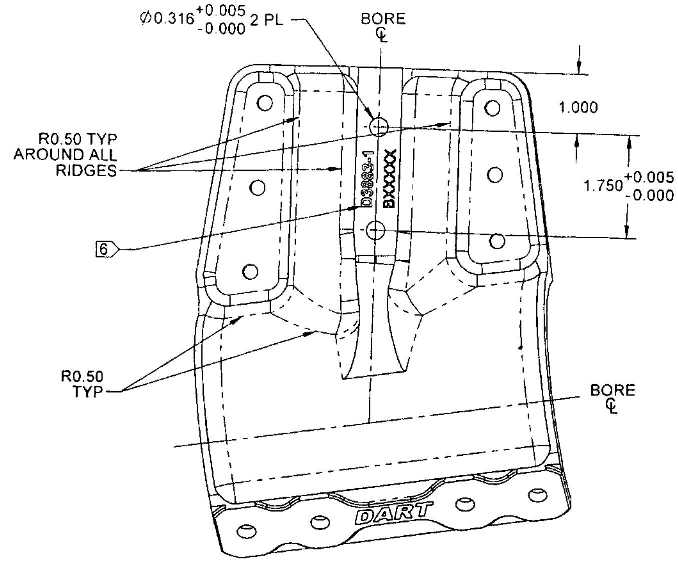
NOTES:
1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
7) WEIGHT: 1.00 lbs
8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

REV.	DESCRIPTION	BY	DATE
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30

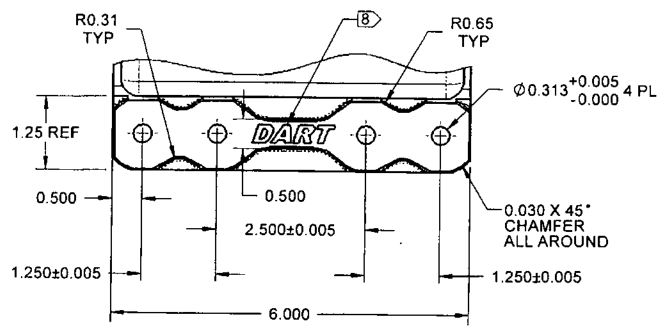
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RF	
CHECKED	[signature]	DRAWING NO. D3883 — REV. C — SHEET 1 OF 2
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE OUTBOARD SADDLE — SCALE NTS
DE APPR.	[signature]	
DATE	09.11.09	



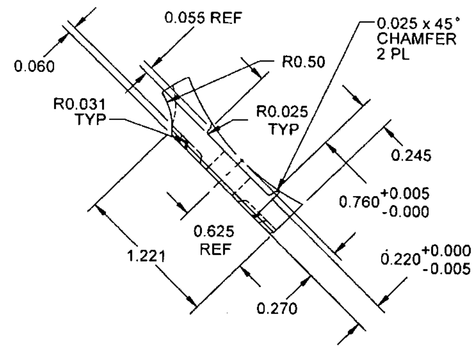
SECTION A-A C7-1



VIEW D-D C7-2



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X

RELEASED
2009-11-19

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RF	
CHECKED	[signature]	DRAWING NO. D3883 — REV. C — SHEET 2 OF 2
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE OUTBOARD SADDLE — SCALE NTS
DE APPR.	[signature]	
DATE	09.11.09	